

Work Order ID 81317

81317

Page 1

March-12-12 4:47:14 PM

Item ID: D2512

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Basket Lid 205/350

Start Date: 12/03/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 26/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/03/13

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2512	Rev E								

100 Weld per dwg A/R S.S. rod Batch: M118366 0.00
Large Fab

100

Large Fab

Large Fab

Memo

0.00

1-Cut 3/4" x 3/4" square tubing as per Dwg D2512
2-Cut (4) D2236 From D3166-3
3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305
4-Weld as per Dwg D2512 using Welding Jig DT 9436
Deburr as required
INSTALL D2012-117 CLEVIS ONLY ON D130-701-041

Pl 12.03.16 1x Ø

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC

Memo

0.00

Quality Control

BE
12.03.20 1 Ø

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 81317

March-12-12 4:47:14 PM

81317

Page 2

Item ID: D2512 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Basket Lid 205/350
 Start Date: 12/03/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 26/03/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00							
120									
QC	Memo	0.00							
Quality Control									
125	Pressure Wash per QSI005 4.3	0.00							
125									
HandFinish	Memo	0.00							
Hand Finishing									

1 14/03/21 SH

1 14/03/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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March-12-12 4:47:14 PM

81317

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N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 12/03/2012 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 26/03/2012 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Run Start *NR1*

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0,00

130

Memo

0.00

Powdercoat

1- Plug holes in D2581 and in D2327-1 bushing prior to Powdercoat

1ST COAT:

START TIME:

OVEN TEMPERATURE

FINISH TIME:

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00

140

HandFinishing

HandFinish

Memo

0.00

Hand Finishing

Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4

Batch: 119044

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Item ID: D2512 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Basket Lid 205/350
Start Date: 12/03/2012 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 26/03/2012 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150 QC3- Inspect Part Finish 0.00

150

QC Memo 0.00

Quality Control

IX M/L 12/03/22

160 Identify as per dwg & Stock Location: *67A* 0.00

160

Packaging Memo *W/081302* 0.00

Packaging

12/03/22 @

170 QC21- Final Inspection - Work Order Release 0.00

170

QC Memo 0.00

Quality Control

12/3/26

1203-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

March-12-12 4:47:17 PM

Page 1

Work Order ID: 81317

81317

Parent Item: D2512

D2512

Parent Item Name: Basket Lid 205/350

Start Date: 12/03/2012

Required Date: 26/03/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

Rev IPP:M03.01.31 AddedD2012-117forD130-701-041KJ/RF
 IPP Rev:N06.04.05 Added level21 EC
 IPP REV:O ADDED D3490-1/-3 FOR D130-701-011/-043 10-04-20 JLM
 VERIFIED BY:DD
 IPP Rev:P 08-08-29 revE as per dwg DD verified by:EC
 IPP Rev:Q 08-09-24 plug holes prior to powder coating DD verified
 by:EC IPP Rev:R
 10.06.29 added pressure wash DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2012-117

Manufactured

No

100

Each

35.0000

2

2

D2012-117

Clevis

Location

Loc Qty

Loc Code

WA005

35

55729

4

69890

31

*** ONLY APPLICABLE ON D130-701-041 -IF
 NOT USED, PLEASE MARK N/A ***

D2232-1

Manufactured

No

100

Each

18.0000

2

2

D2232-1

Basket Hinge

Location

Loc Qty

Loc Code

WA

18

78992

10

79472

8

D2327-1

Manufactured

No

100

Each

35.0000

2

2

D2327-1

Spacer Bushing

Location

Loc Qty

Loc Code

WA005

35

69728

9

73692

26

W/O:		WORK ORDER CHANGES					
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Page 2

Work Order ID: 81317

81317

Parent Item: D2512

D2512

Parent Item Name: Basket Lid 205/350

Start Date: 12/03/2012

Required Date: 26/03/2012

Start Qty: 1.00

Required Qty: 1.00

D2506

Manufactured No

100

Each

10.0000

1

1

D2506

Label Plate

**

PL 12.03.15

Location

Loc Qty

Loc Code

WA006

10

79197

10

1

D2581

Manufactured No

100

Each

33.0000

2

2

D2581

Mounting Bracket

**

PL 12.03.15

Location

Loc Qty

Loc Code

WA005

33

69739

1

70766

2

77045

3

77523

27

2

D3166-3

Manufactured No

100

Each

4.0000

1

D3166-3

Basket Hoop

**

PL 12.03.15

Location

Loc Qty

Loc Code

WA007

4

77294

4

1

March-12-12 4:47:18 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 3

Work Order ID: 81317

81317

Parent Item: D2512

D2512

Parent Item Name: Basket Lid 205/350

Start Date: 12/03/2012

Required Date: 26/03/2012

Start Qty: 1.00

Required Qty: 1.00

M304EX0.75-16F

Purchased

No

100

sf

825.8696

18

18.94737

M304EX0 75-16F

Expanded Metal Flat SS

**

12.03.16

Location

Loc Qty

Loc Code

WA

0.0001156

119180

0.0001156

WA035

825.8694457

117197

102.9036

117896

29.49258

118153

76.8473

118955

82.17

119180

53.6958107

119729

28.1132686

120153

2.97557478

120318

129.671312

120917

1320

18.94737

~~37.89974~~

M304TS0.750W.065

Purchased

No

100

f

664.5479

43.5804

45.87411

M304TS0 750W 065

304 SQ Tube .75x.75x.065W

**

12.03.15

Location

Loc Qty

Loc Code

MAT017

616.890429

120267

116.890429

120633

500

MAT018

41

7636

41

WA007

0.5907428

116763

0.5907428

WA035

6.0667

118181

6.0667

M 116267

92.52 7.71

M 117636

38.164

March-12-12 4:47:18 PM

Shop Packet Print

Page 3

3x30.84

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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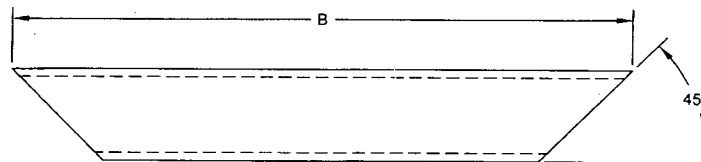
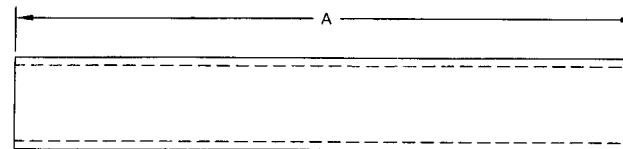
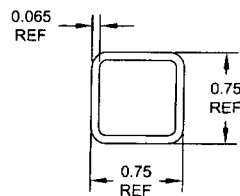
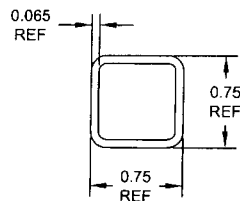
NOTE: Date & initial all entries

PARTS LIST FOR D2512 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	—	25.50	RIB
D2512-3	2	—	95.30	RIB
D2512-5	6	30.84	—	RIB
D2512-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRACKET

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 81317 MLU
12/03/13

RELEASED
06-08-21/17



E

D2512-1/-3/-5/-7 NOTES:

- 1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

E	INCORPORATED D1 & D2. MATERIAL FOR -1, -3, -5, & -7 WAS 0.060 WALL. SHT 3 ZN C4 TOLERANCE REMOVED FROM 95.30 DIM. DRAWING TRANSFERRED TO "B" FORMAT AND UPDATED TO CURRENT STANDARDS. SHT 3 VIEWS INVERTED FOR CLARITY. SHT 2 MESH MATERIAL CALLOUT UPDATED.	AJS	08.06.17
D	CHANGE HINGE	CP	01.04.19
C	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP DEO 9074	DS	99.07.06
B	ADDED LATCH CHANNEL & LABEL PLATE	BW	96.05.24
A	NEW ISSUE	BW	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION, THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS, WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

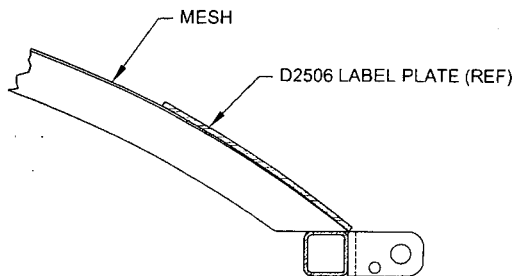
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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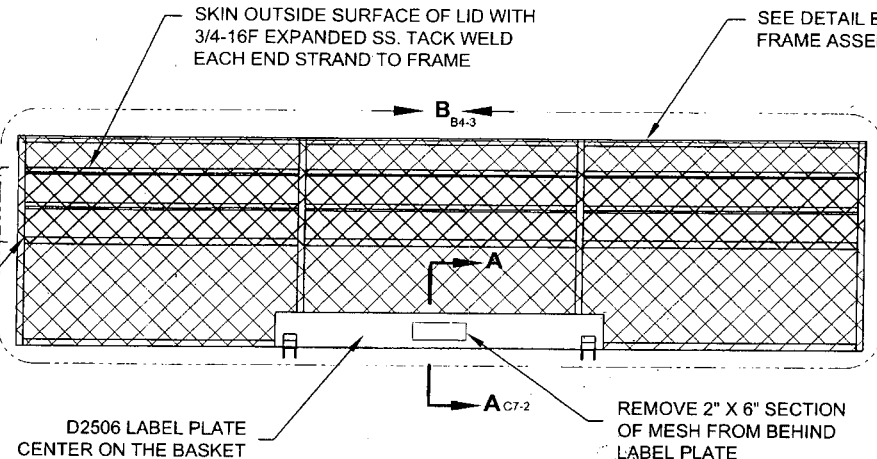
81317



SECTION A-A^{B3-2}
(ROTATED 90° CCW)

FINISH THIS SECTION ALONG
ENTIRE LENGTH PER NOTE 3
AFTER POWDER COAT.

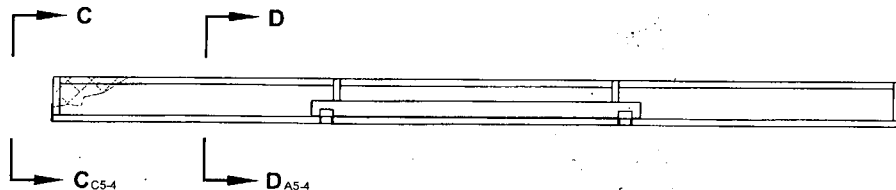
TACK WELD MESH TO FRAME
AT EVERY AVAILABLE LOCATION
IN AREA TO BE ANTI-SKIDDED



E

D2512 BASKET LID ASSEMBLY NOTES:

- 1) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) SPRAY PAINT BLACK INSIDE SURFACE
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: N/A
- 9) WELD PER DART QSI 004



RELEASED
08.06.17

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	<small>COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

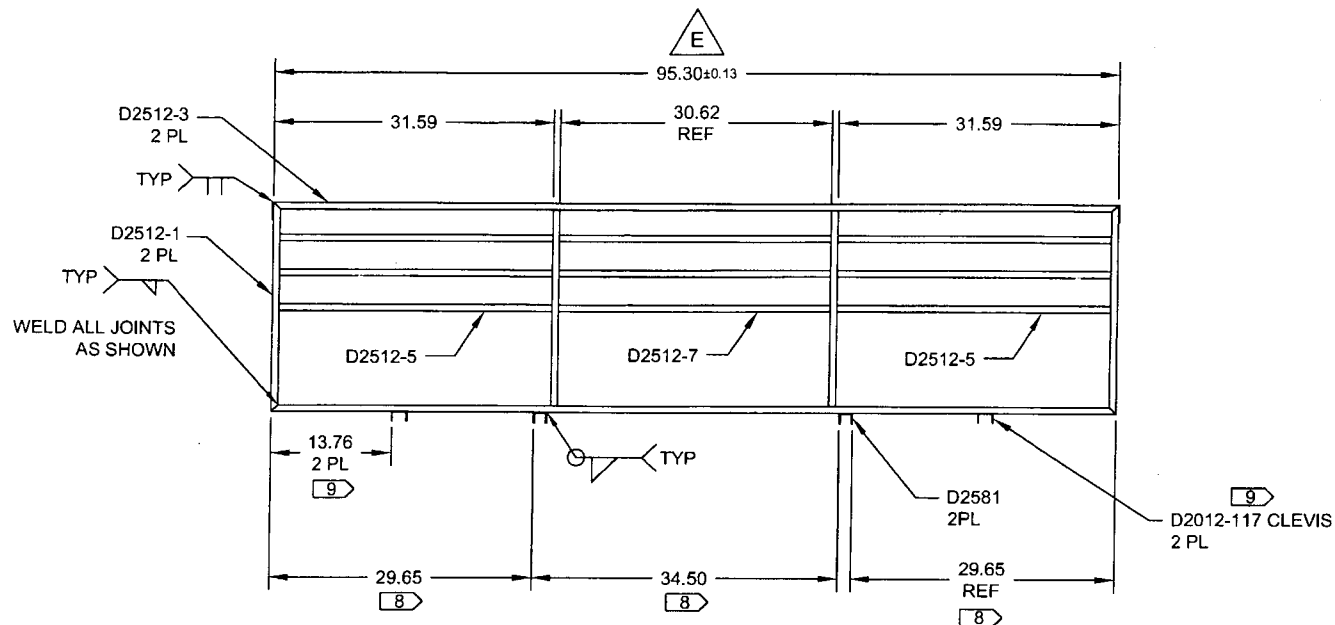
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

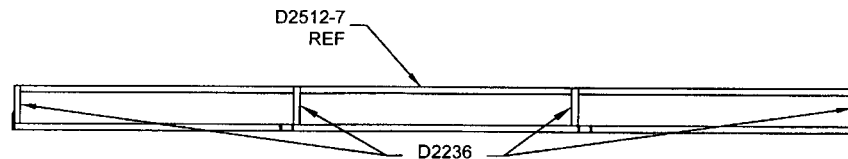
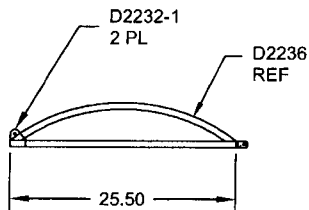
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DETAIL B C3-2
FRAMEWORK ONLY SHOWN FOR CLARITY



NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) LOCATE IN CONJUNCTION WITH ADJACENT D2581 ON BASKET BASE ASSEMBLY
- 9) FOR D130-701-041 ONLY

RELEASED
08.06.17

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	J	DRAWING NO.	REV. E
MFG. APPR.	B	D2512	SHEET 3 OF 4
APPROVED	AP	TITLE	SCALE
DE APPR.	A	BASKET LID ASSEMBLY (350/212)	NTS
DATE 08.06.17		COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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D2232-1
HINGE PLATE
(TYP BOTH ENDS)

TRIM MESH AS REQUIRED
TO ALLOW D2232-1 HINGE PLATE
TO SIT FLUSH ON FRAME

DRILL 3/8 HOLE AND
INSTALL D2327-1 USING
CLOSEST SPACE IN
EXPANDED METAL
FOR HOLE LOCATION
BOTH ENDS

DETAIL E

8.00

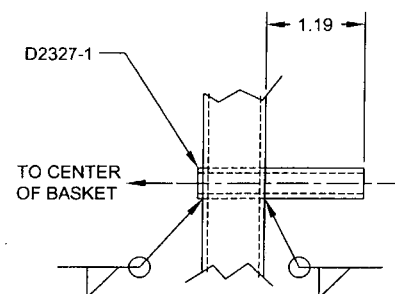
VIEW C-C SIMILAR BOTH END RIBS A5-2

4.00
2X 3 PL

EXPANDED METAL

CL

SECTION D-D SAME BOTH CENTER RIBS A4-2



DETAIL E C6-4

RELEASED

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
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